

Work Order ID 128812

Tuesday, January 27, 2015 7:48:38 AM

128812

Page 1

Item ID: D4092-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step
 Start Date: 1/26/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLD Date: 15-01-28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4092	B

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw									

110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA935								
	Dwg Rev: <u>B</u>								
	Folio rev: <u>AA</u>								
	Deburr								

****Grind flush transition machining mark after machining bottom of extrusion, see detail A.****

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, January 27, 2015 7:48:38 AM

128812

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/26/15 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 1/26/15 **Req'd Qty:** 8.00 ***O***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

QC

Memo

0.00

Quality Control

140

0.00

140

HandFinish

Memo

0.00

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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128812

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name:	Maintenance Step
1. Check oil level	1. Check oil level
2. Check tire pressure	2. Check tire pressure
3. Check brake pads	3. Check brake pads
4. Check engine oil	4. Check engine oil
5. Check battery	5. Check battery
6. Check air filter	6. Check air filter
7. Check spark plugs	7. Check spark plugs
8. Check coolant level	8. Check coolant level
9. Check transmission oil	9. Check transmission oil
10. Check suspension	10. Check suspension
11. Check steering	11. Check steering
12. Check exhaust system	12. Check exhaust system
13. Check headlights	13. Check headlights
14. Check horn	14. Check horn
15. Check windshield wipers	15. Check windshield wipers
16. Check door locks	16. Check door locks
17. Check seat belts	17. Check seat belts
18. Check interior lights	18. Check interior lights
19. Check exterior lights	19. Check exterior lights
20. Check mirrors	20. Check mirrors
21. Check door hinges	21. Check door hinges
22. Check door seals	22. Check door seals
23. Check door handles	23. Check door handles
24. Check door latch	24. Check door latch
25. Check door lock cylinder	25. Check door lock cylinder
26. Check door lock mechanism	26. Check door lock mechanism
27. Check door lock wiring	27. Check door lock wiring
28. Check door lock solenoid	28. Check door lock solenoid
29. Check door lock actuator	29. Check door lock actuator
30. Check door lock assembly	30. Check door lock assembly
31. Check door lock cover	31. Check door lock cover
32. Check door lock trim	32. Check door lock trim
33. Check door lock hardware	33. Check door lock hardware
34. Check door lock components	34. Check door lock components
35. Check door lock parts	35. Check door lock parts
36. Check door lock materials	36. Check door lock materials
37. Check door lock tools	37. Check door lock tools
38. Check door lock equipment	38. Check door lock equipment
39. Check door lock supplies	39. Check door lock supplies
40. Check door lock services	40. Check door lock services
41. Check door lock professionals	41. Check door lock professionals
42. Check door lock experts	42. Check door lock experts
43. Check door lock specialists	43. Check door lock specialists
44. Check door lock technicians	44. Check door lock technicians
45. Check door lock workers	45. Check door lock workers
46. Check door lock laborers	46. Check door lock laborers
47. Check door lock assistants	47. Check door lock assistants
48. Check door lock helpers	48. Check door lock helpers
49. Check door lock apprentices	49. Check door lock apprentices
50. Check door lock trainees	50. Check door lock trainees
51. Check door lock students	51. Check door lock students
52. Check door lock scholars	52. Check door lock scholars
53. Check door lock graduates	53. Check door lock graduates
54. Check door lock professionals	54. Check door lock professionals
55. Check door lock experts	55. Check door lock experts
56. Check door lock specialists	56. Check door lock specialists
57. Check door lock technicians	57. Check door lock technicians
58. Check door lock workers	58. Check door lock workers
59. Check door lock laborers	59. Check door lock laborers
60. Check door lock assistants	60. Check door lock assistants
61. Check door lock helpers	61. Check door lock helpers
62. Check door lock apprentices	62. Check door lock apprentices
63. Check door lock trainees	63. Check door lock trainees
64. Check door lock students	64. Check door lock students
65. Check door lock scholars	65. Check door lock scholars
66. Check door lock graduates	66. Check door lock graduates
67. Check door lock professionals	67. Check door lock professionals
68. Check door lock experts	68. Check door lock experts
69. Check door lock specialists	69. Check door lock specialists
70. Check door lock technicians	70. Check door lock technicians
71. Check door lock workers	71. Check door lock workers
72. Check door lock laborers	72. Check door lock laborers
73. Check door lock assistants	73. Check door lock assistants
74. Check door lock helpers	74. Check door lock helpers
75. Check door lock apprentices	75. Check door lock apprentices
76. Check door lock trainees	76. Check door lock trainees
77. Check door lock students	77. Check door lock students
78. Check door lock scholars	78. Check door lock scholars
79. Check door lock graduates	79. Check door lock graduates
80. Check door lock professionals	80. Check door lock professionals
81. Check door lock experts	81. Check door lock experts
82. Check door lock specialists	82. Check door lock specialists
83. Check door lock technicians	83. Check door lock technicians
84. Check door lock workers	84. Check door lock workers
85. Check door lock laborers	85. Check door lock laborers
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90. Check door lock students	90. Check door lock students
91. Check door lock scholars	91. Check door lock scholars
92. Check door lock graduates	92. Check door lock graduates
93. Check door lock professionals	93. Check door lock professionals
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95. Check door lock specialists	95. Check door lock specialists
96. Check door lock technicians	96. Check door lock technicians
97. Check door lock workers	97. Check door lock workers
98. Check door lock laborers	98. Check door lock laborers
99. Check door lock assistants	99. Check door lock assistants
100. Check door lock helpers	100. Check door lock helpers

Start Date: 1/26/15 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 1/26/15 **Req'd Qty:** 8.00 ***O***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

Wing Walk as per dwg QSI005 4.4 Batch

0.00

155

Memo

0.00

HandFinish

Hand Finishing

160

QC3- Inspect Part Finish

0.00

160

Memo

0.00

OC

Quality Control

170

Identify as per dwg & Stock Location

0.00

170

Memo

0.00

Packaging

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128812

Tuesday, January 27, 2015 7:48:38 AM

128812

Page 4

Item ID: D4092-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step

Start Date: 1/26/15

Start Qty: 8.00

g

Cust Item ID:

Required Date: 1/26/15

Req'd Qty: 8.00

g

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 15-02-29

MF
15-2-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Picklist Print

Tuesday, January 27, 2015 7:48:38 AM

Page 1

Work Order ID: 128812

128812

Parent Item: D4092-1

D4092-1

Parent Item Name: Maintenance Step

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 8.00

Required Qty: 8.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108		Manufactured	No			100	f	234.1000	2.5	21.05263			

D2761-108

Extrusion (HPK)

215-2-14

Location

Loc Qty

Loc Code

MAT051

234.1

80206

234.1

23.1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order: 128812
Description: Maintenance Step		Part Number: D4092-1
Inspection Dwg: D4092	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

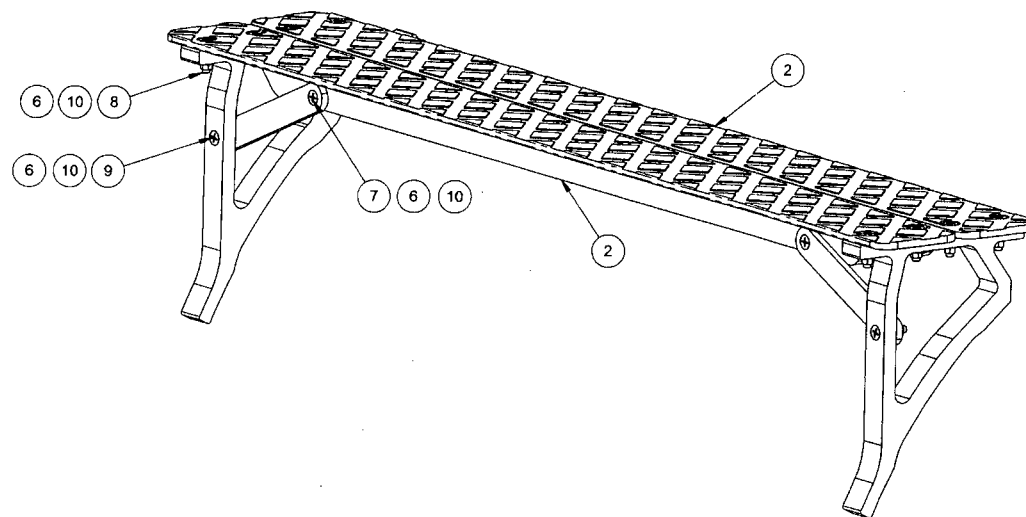
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/-0.030	30.060	✓		MJP-07	Tape
0.19	+/-0.030	0.182	✓		MJP-04	vern
1.25	+/-0.030	1.245	✓		...	...
1.38	+/-0.030	1.371	✓			
0.25	+/-0.030	0.244	✓		↓	↓
R0.25	+/-0.030	0.250	✓		—	Radius gauge
2.50	+/-0.030	2.495	✓		MJP-04	vern
Ø0.201	+0.005/-0.001	0.203	✓		...	...
0.30	+/-0.030	0.297	✓			
4.78	+/-0.030	4.780	✓		31006	Height gauge
1.69	+/-0.030	1.690	✓		...	...
2.96	+/-0.030	2.96	✓		...	...
0.030	+/-0.010	0.030	✓		MJP-08	Dial depth mic
0.20	+/-0.030	0.205	✓		MJP-04	vern
R 0.50	+/-0.030	0.500	✓		—	Radius gauge
0.035	+/-0.010	0.037	✓		MJP-05	Depth mic
0.390 x 100°	+/-0.010 x 0.5°	0.390 x 100°	✓		MJP-04	vern
1.500	+/-0.130	1.500	✓		...	...
0.50	+/-0.030	0.501	✓			
1.25	+/-0.030	1.250	✓			
0.69	+/-0.030	0.690	✓			
0.38	+/-0.030	0.380	✓			
0.69	+/-0.030	0.690	✓		↓	↓

Measured by: <i>[Signature]</i>
Date: 15/02/18

Audited by: DAS 14
Date: 15/02/20

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	13.06.18	Dimension 2.96 was 2.69	KJ	



D4092-041 MAINTENANCE STEP ASSEMBLY



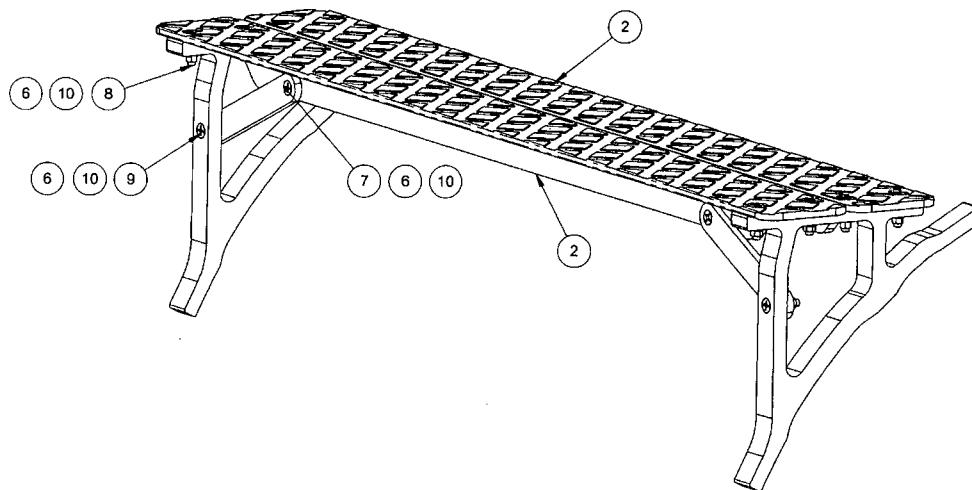
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

128812 M.C.S
15-01-28

RELEASED
2011-09-22
JWD

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 1 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

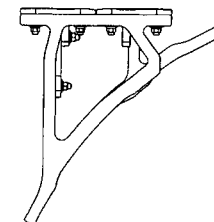
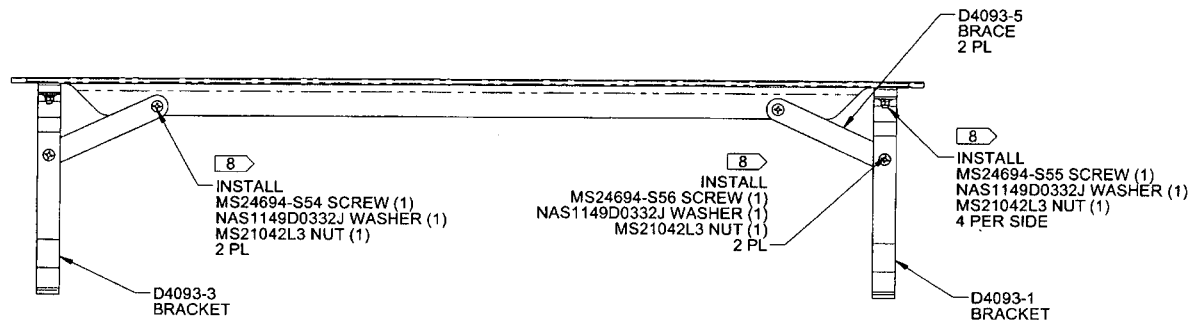
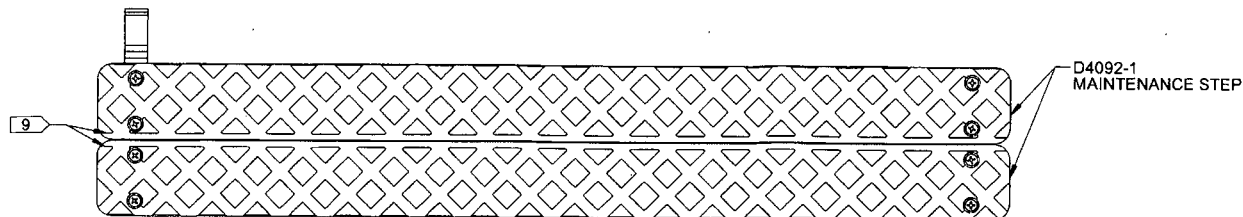


D4092-042 MAINTENANCE STEP ASSEMBLY



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2011-09-20
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DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 2 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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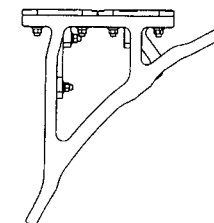
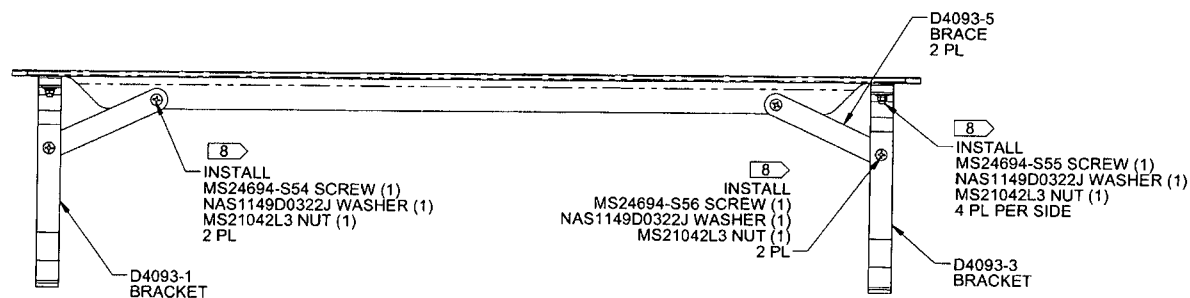
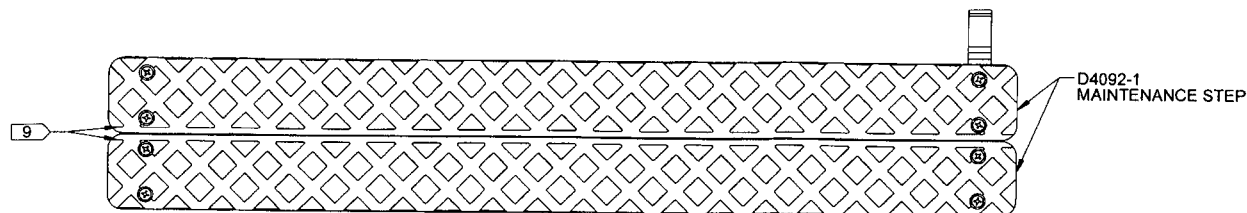
D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-09-22

DESIGN		RF		DART AEROSPACE USA, INC.	
DRAWN		RF		KENT, WA	
CHECKED		140		DRAWING NO.	REV. B
MFG. APPR.		21		D4092	SHEET 3 OF 6
APPROVED		140		TITLE	SCALE
DE APPR.		140		MAINTENANCE STEP ASSY	
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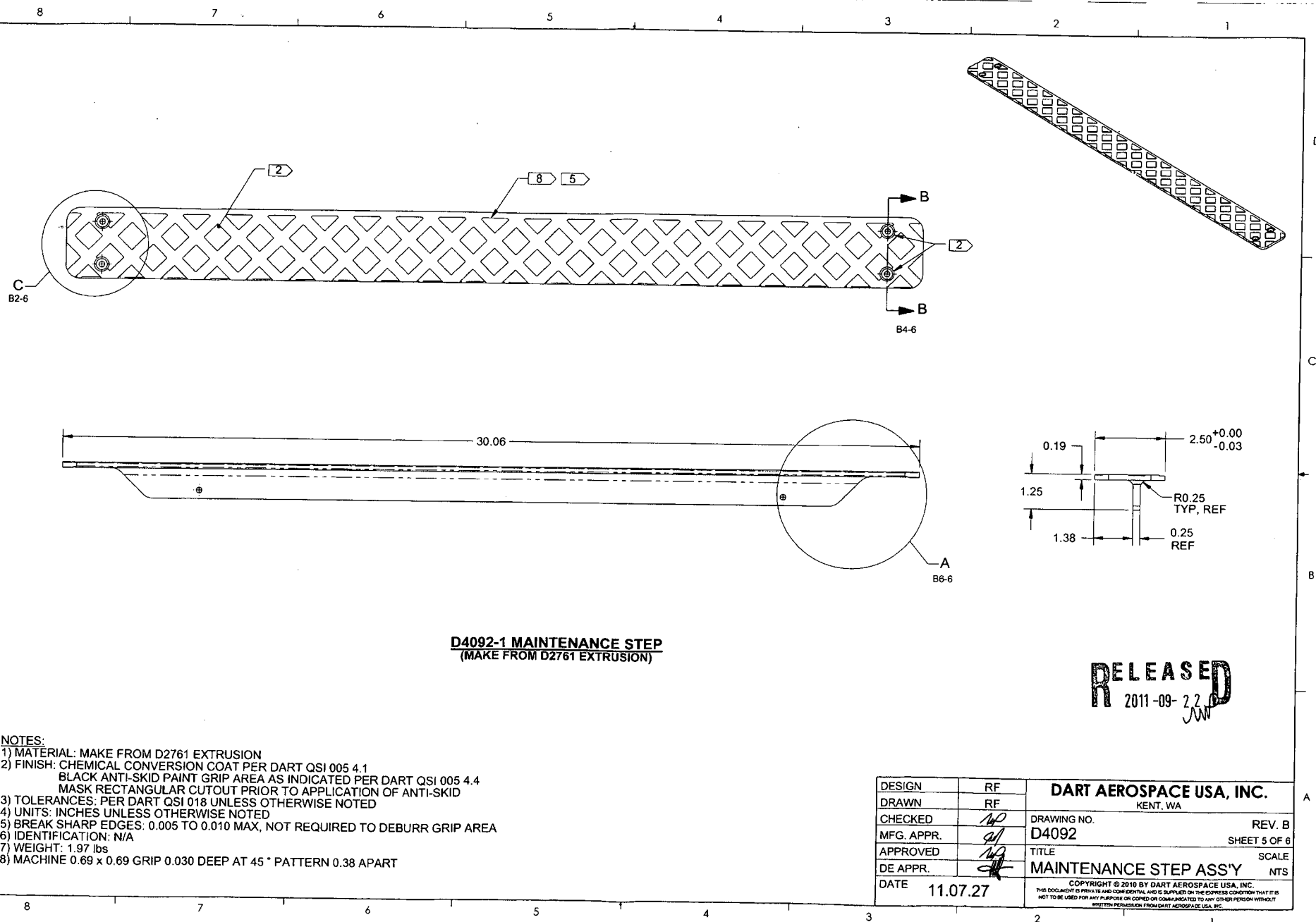
D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 4 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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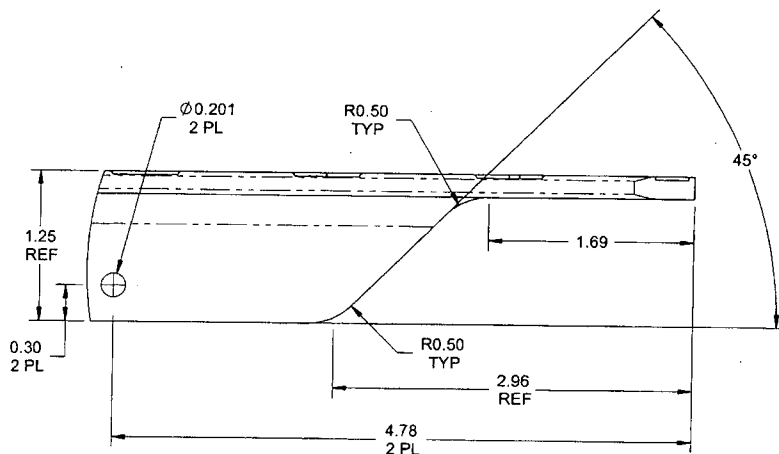
D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

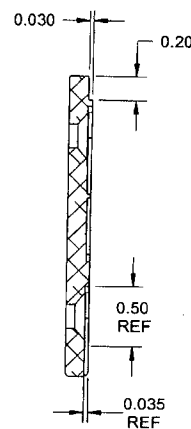
- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45 ° PATTERN 0.38 APART

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2011-09-22
JW

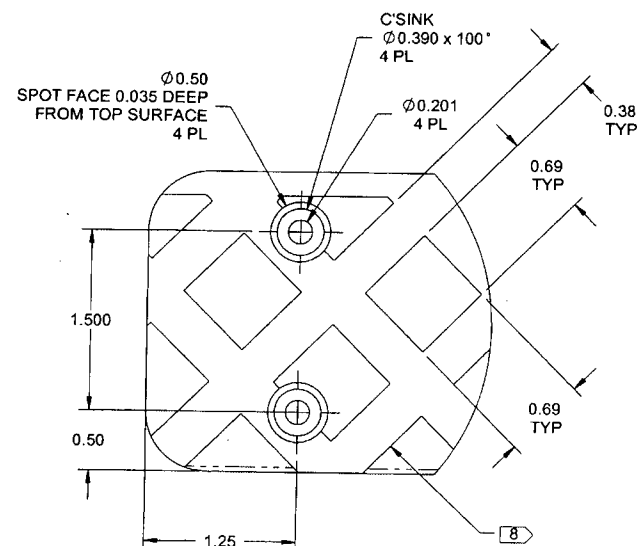
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 5 OF 6
APPROVED	149	TITLE	SCALE
DE APPR.	149	MAINTENANCE STEP ASS'Y	NTS
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DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

RELEASED
2011-09-22
AWO

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO. D4092	REV. B
MFG. APPR.	<i>RF</i>	SHEET 6 OF 6	
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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